

Date: Thursday, 6/29/2006 10:54:16 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	X-BOLT SPACER
Job Number :	27777		
Estimate Number :	12468		
P.O. Number :	N/A	Part Number :	D35041
This Issue :	6/29/2006	Drawing Number :	D3504 PRELIMINARY
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	N/A	Drawing Revision :	PREL
Previous Run :	27717	Material :	N/A
	Type :	Due Date :	7/6/2006
	MACHINED PARTS	Qty:	20 Um: Each
Written By :	SEE COMMENT BELOW		
Checked & Approved By :	06 06.29		
Comment :	Est Rev:A New Issue 06-06-20 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0500W049	6061-T6 Tube .500 x.049W
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Comment: Qty.: 0.2972 f(s)/Unit Total: 2.9715 f(s)
 6061-T6 Tube .500 x.049W
 (M6061T6T500W049)
 Batch: M9328 70"

MS 06/07/02

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 1-TURN AS PER FOLIO FA642 & DWG D3504,
 FOLIO REV: N/A (new issue)
 DWG REV: A

2-DEBURR AS REQUIRED

MS 06/07/02 20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/07/02 20

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

En 06/07/04 x20

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: ST 448

H.M 06-07-04

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/07/05

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/29/2006 10:54:16 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-BOLT SPACER

Job Number: 27777

Part Number: D35041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/07/05

Job Completion



U 86-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

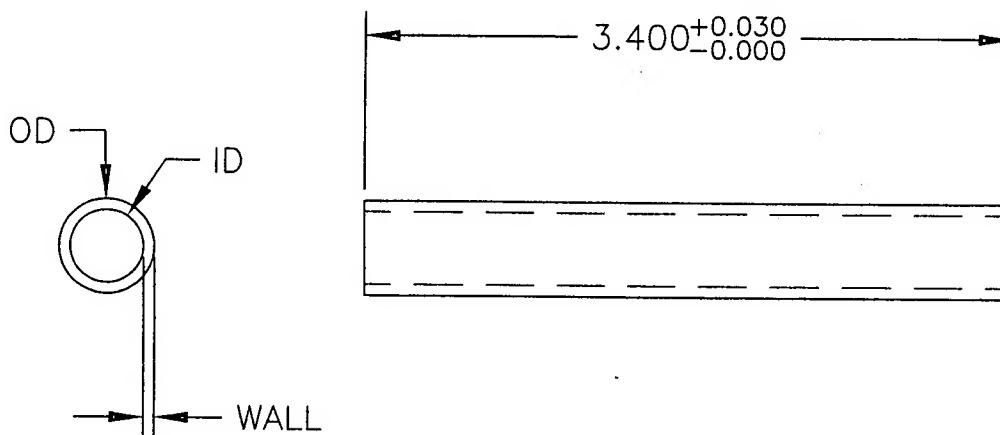
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
06-06-19 PH

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3504	REV. A SHEET 1 OF 1
DATE 06.04.21		TITLE CROSS BOLT SPACER	SCALE 1:1
A	06.04.21	NEW ISSUE	

PRELIMINARY ISSUE



D3504-1/-3 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3504-1	0.500 <i>647</i>	0.049	0.402	M6061T6T0.500W.049
D3504-3	0.375 <i>647</i>	0.049	0.277	M6061T6T0.375W.049

D3504-1/-3 CROSS BOLT SPACER

- 1) MATERIAL: 6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 *SHOP COPY*
- 2) FINISH: NONE *RETURN TO*
- 3) ALL DIMENSIONS ARE IN INCHES *ENGINEERING*
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED *UNCONTROLLED COPY*

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27777

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09/21/2000 From: MARMON/KEYSTONE
 C.O.: BN4879
 M/K OR: 8014634

INIT.: VH

C PART:

BR. OR:

To: M/K - BURLINGTON

KAISER CHANDLER**CERTIFICATION and
PHYSICAL TEST RESULTS**

QP 026A

These results are for

MARMON/KEYSTONE CORP

Mill Number

176-29852.Purchase Order No **80-4573-001**

Alloy

6061Temper: **T6**

Part No, Item No, Commodity No or Inventory No

Size Description

.500" OD X .049" WALL

Specification(s)

WW-T-700/6FA2 ASTM B210-95 AMS 4082M

Additional procedures as called for on Specification.

WE TAKE EXCEPTION TO PARA. 6.2.1. WAS NOT OILED. (HEAT TREAT LOT # 29851 C.D.)

Limits	Chemical Composition										Per Aluminum Association and Data Eleventh Edition August 1993	
	A - .80	70	.15 - 0.415	0.8 - 1.2	0.4 - .35	...	0.25	.15	Each .05 Total .15	Remainder
	Si	Fe	Cu		Mn	Mg	Cr		Zn	Ti	Others	Al
Actuals	.58	.24	0.20		.03	0.95	.05		0.03	.03		
											Each .05	Remainder
											Total .15	

* For WW-T-7004 specification, maximum Si plus Fe is .45%.

Mechanical Properties	Yield PSI	Ultimate PSI	Elongation %
	41,160	45,930	16
	41,410	45,870	16

We hereby certify that the material covered by this report has been inspected in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description; and that samples representative of the material met the composition limits and had the mechanical properties as indicated.

Certified Date 08/16/2000

*C E Brooks*C. E. BROOKS
Tech. Mgr. Tube